

Date: Thursday, 12/21/2006 12:02:21 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY  
Job Number : 30069  
Estimate Number : 11999  
P.O. Number : *N/A* Part Number : D350591122  
This Issue : 12/21/2006 S.O. No. : *N/A* Drawing Number : D2351 REV E  
Prsht Rev. : NC Project Number : N/A  
First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : E  
Previous Run : 28760 Material : *N/A*  
Written By : Due Date : 1/20/2007 Qty: 5 Um: Each  
Checked & Approved By : *JA 061221*  
Comment : Est Rev: E 02.10.21 Re-format; Incorporated D2351-041 IPP K  
J/RF

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-122 CHG003

2.0 D2244116 Step Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total: 2.5000 Each(s)

Pick:

Qty Part Number Description Batch

0.5 D2244-128 Extrusion

*B23404 x 3**B31406*  
*B28216 x 2 Rework**B28216 x 2 FF 07-02-28*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

*FF 07-02-28*

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

*FF 07-02-28*

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*02/03/05*

5.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Bend as per dwg

*DA/EL**07/03/05*

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Job Number: 30069

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Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/07/03/12 (7)

7.0

D28502

End Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2850-2 End Bracket 310952

12/07/03/31

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Fwd and Aft end for welding

12/07/03/31

2-Weld Aft End Bracket per QSI 004 & Dwg D2351 using Welding Jig DT8033

A/R Aluminum Rod M100237  
M102255

12/07/03/31

3-Do not Grind Flush

12/07/03/31

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

12/07/04/02

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/07/04/02

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

12/07/04/02

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12/07/04/02



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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D2582

Hi-Skid Step Leg Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2582

Step Leg Assy 329922

*SE. 07.04.02 /*

14.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W3 Rivet

B14393

*SE. 07.04.02 /*

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Rivet Leg Assembly as per Dwg D2351

*SE. 07.04.02 /*

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/04/02*

17.0

D267334

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2673-34 End Plate

325396

*SE. 07.04.02 /*

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R Aluminum Rod m100237

2-Grind end plate flush.

*SE. 07.04.02 /*

*SE. 07.04.02 /*

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Drawing Name: SHORT STEP ASSEMBLY

Job Number: 30069

Part Number: D350591122

Job Number:



Seq. #: Machine Or Operation: Description :

19.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

AA 07/04/02 ①

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 07/04/02 ①

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

dh

07-04-02 ①

22.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m103706

FL

07/04/02 ①

23.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk per Dwg D2351 and QSI 005 4.4

Batch: m103707

FL

07/04/03 ①

24.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-l

07/04/03 ①

25.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0 D22301 Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick:

Packing Kit Qty Part Number Description Batch  
1 D2230-1 Mounting Lug 130155

07/04/02 SF



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Drawing Name: SHORT STEP ASSEMBLY

Job Number: 30069

Part Number: D350591122

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

D22303

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch  
1 D2230-3 Mounting Lug B30545 ✓

28.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 3.0000 f(s)

Pick:

Packing KitQty Part Number Description Batch  
1 D2856-400 7.20" Abrasion Strip B29850 ✓

29.0

AN337A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch  
2 AN3-37A Bolt M103926 ✓

30.0

AN413A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 15.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch  
3 AN4-13a Bolt M102189 ✓

31.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch  
4 AN960JD10 Washer M100274 ✓

32.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch  
6 AN960JD416 Washer M102929 ✓

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Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

2 MS21042L3 Nut (or -3) 11/022/17

34.0

MS21042L4

Nut



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Pick:

Packing KitQty Part Number Description Batch

3 MS21042L4 Nut (or -4) 11/039/14

02/04/02 Sra

35.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-122

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/03

Job Completion



U 07.01.04



**DART**

DESIGN KE	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

**D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST**

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

\*cut per drawing

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 30069

**RELEASED**  
05.11.28

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Job Number	: 30069		
Estimate Number	: 11999		
P.O. Number	:	Part Number	: D350591122
This Issue	: 12/21/2006 S.O. No. :	Drawing Number	: D2351 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: E
Previous Run	: 28760	Type	: LARGE FAB ASSY
Written By	: <u>                    </u>	Material	:
Checked & Approved By	: <u>                    </u>	Due Date	: 1/20/2007
Comment	: Est Rev:E 061221 Re-format; Incorporated D2351-041 IPP K		
	J/R/F		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-122 CHG003

06 12 21                     

2.0	D2244116	Step Extrusion
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Comment: Qty.: 0.5000 Each(s)/Unit Total : 2.5000 Each(s)

Pick:

Qty Part Number Description Batch

0.5 D2244-128 Extrusion

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2244-128 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Bend as per dwg

REFERENCE ONLY